

Work Order ID 165815

Tuesday, August 29, 2017 3:23:28 PM

165815

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Item ID: D5393-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Weldment
 Start Date: 9/11/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/18/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: UM ^{DAS} 21 ₉₋₈₉ Date: AUG 30 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5393	B								

110 Weld per dwg A/R S.S. rod Batch: M134992 0.00

110

Large Fab Memo 0.83

Large Fab 1- CUT TUBE TO LENGHT AS PER DWG

2- WELD STUD TO STRUT AS PER DWG

3- GRIND WELD FLUSH

1 QL 17-09-12

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC Memo 0.00

Quality Control

/ SEP 13 2017 ^{DAS} 24 ₉₋₈₉

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				<u>1</u>	SEP 13 2017		DAS 24 9-89
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST</u> Memo	0.00 0.01				<u>1</u>			DAS 9-89
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.10							17/9/19 <u>ST</u> DAS 21 9-89

SEP 13 2017

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Page 1

Work Order ID: 165815

165815

Parent Item: D5393-043

D5393-043

Parent Item Name: Strut Weldment

Start Date: 9/11/2017

Required Date: 9/18/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.02.01 NEW ISSUE DD VERF:JLM IPP
REV:B 17.01.27 AS PER DWG REV.B2 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D5393-3		Manufactured	No			110	Each	4.0000	2	2			
D5393-3									**				
Stud													

LocationLoc QtyLoc Code

ST167

4

162938

4

M304TR0.500W.049

Purchased

No

110

f

60.5632

1.7

1.7

M304TR0 500W 049

304 RD Tube .500 x .049W

******LocationLoc QtyLoc Code

GA002

60.563158

M136846

1.17

M137091

1.53

M137169

4.861158

M137415

2.58

M137623

6.582

M137834

13.89

M138184

29.95

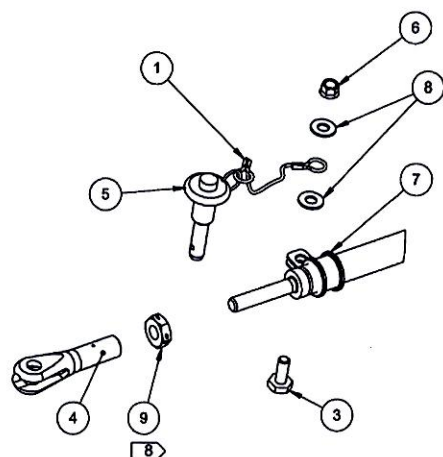
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Q.L 17-09-12

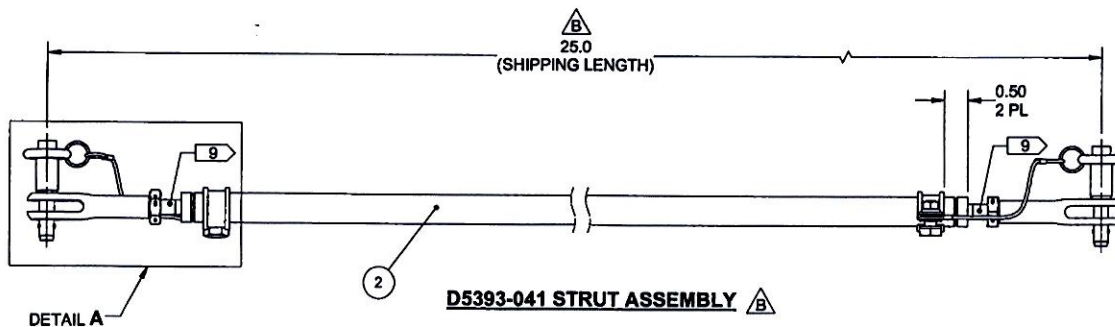
2

Q.L 17-09-12

ITEM	QTY	P/N	DESCRIPTION
	X	D5393-041	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5393-043	STRUT WELDMENT
3	2	AN3C3A	BOLT
4	2	AN665-34R	THREADED CLEVIS
5	2	MS17984-C405	PIN, QUICK RELEASE
6	2	MS21043-3	NUT, SELF-LOCKING
7	2	MS21919WCF8	CLAMP
8	4	NAS1149C0332R	WASHER
9	2	NAS509-4C	NUT, JAM



DETAIL A
2 PL



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WORK ORDER
NO. 165815

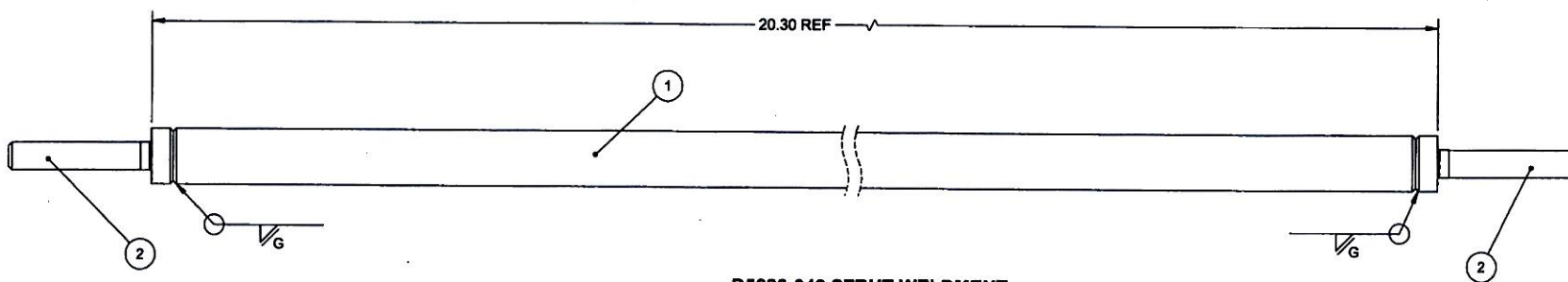
AUG 30 2017

RELEASED
2017-02-10
ECN 17-208
522

B	SHEET 1: ITEMS 4 & 9 WERE IN -043. REMOVE TORQUE NOTE (TORQUE TO BE APPLIED ON INSTALL). SHEET 2 HAND TIGHTEN NOTE FOR NUT MOVED TO SHEET 1. SHEET 3: 19.90 DIM WAS 20.40. SHEET 4 ADDED -3. REASON: NCR18-6129		AJS	16.12.19
A	NEW ISSUE		RF	16.01.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	NO	HAWKESBURY, ONTARIO, CANADA		
CHECKED	AJS	DRAWING NO.	REV. B	
MFG. APPR.	DD	D5393	SHEET 1 OF 4	
APPROVED	WM	TITLE	SCALE	
DE APPR.	DS	STRUT ASSEMBLY	NTS	
DATE	16.12.19		COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 7) WEIGHT: 0.75 lbs
 8) HAND TIGHTEN NAS509-4C NUT
 9) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

ITEM	QTY	P/N	DESCRIPTION
	X	D5393-043	STRUT WELDMENT
1	1	D5393-1	STRUT
2	2	D5393-3	STUD



D5393-043 STRUT WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.51 lbs
- 8) WELD PER DART QSI 004

RELEASED
2017-02-10

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	NO		
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5393	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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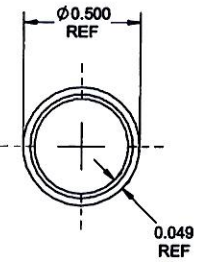
0.030 x 45°
CHAMFER, 2 PL

C

B

19.90

D5393-1 STRUT



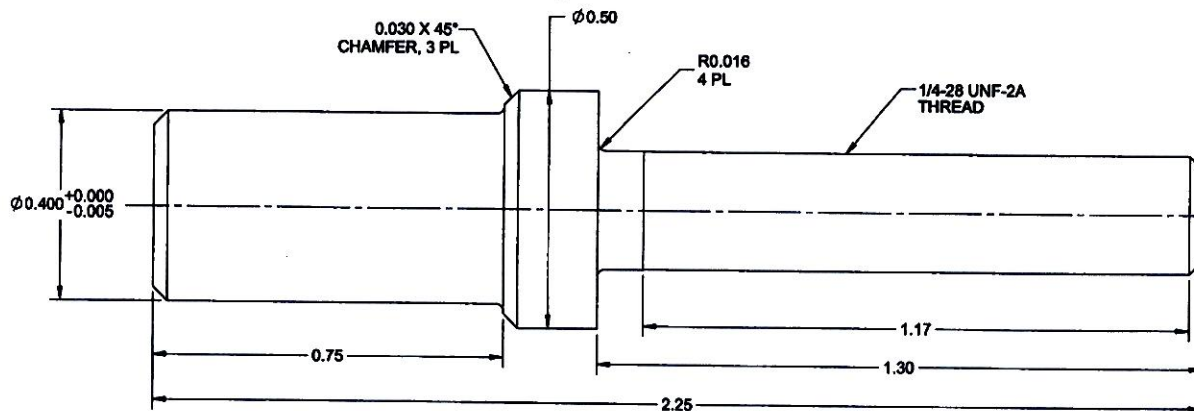
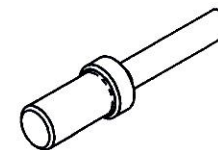
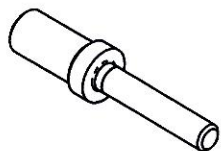
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF. DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

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2017-02-10

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	NO		
CHECKED	AJS	DRAWING NO. D5393	REV. B
MFG. APPR.	DD		SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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D5393-3 STUD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276
REF. DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASED
2017-02-10

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DRAWN	NO	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	DD	D5393	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
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